

Date: Tuesday, 10/2/2007 10:37:00 AM
 User: Kim Johnston

Process Sheet

46

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 CARGO MIRROR
 Job Number : 34922
 Estimate Number : 10095
 P.O. Number : N/A Part Number : D044715011
 This Issue : 10/2/2007 S.O. No. : N/A Drawing Number : D3243REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 32763 Material : Manufacture in multiples of 10
 Due Date : 11/11/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : 07.10.02
 Comment : Est Rev:A 04.02.18 New issue KJ/JLM
 Est Rev:B 06-04-28 Manufactured on Water Jet JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

(6)

1.0

DC

DOCUMENT CONTROL



RS 07.10.15

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-715-011

CHG001

2/2/18

2.0

M6061T6S063

6061-T6 .063 Sheet



3.2154

Comment: Qty.: 0.5359 sf(s)/Unit Total : 2.6796 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063)Identify for D3244-1

Batch: M1052251807-10-4

3.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3243

Dwg Rev: AProg Rev: A1807-10-4

(6)

2-Deburr if necessary

1807-10-4

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

1807-10-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 1807-10-4 (46)

counters

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:37:00 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 CARGO MIRROR

Job Number: 34922

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3243

SB 07/11/21 (6)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 07/11/21 (6) counters

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FL 07/11/21 (6)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/12/05 x6

10.0

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s) 24

Pick:

Qty Part Number

Description

Batch

4 FE-032EF

Insert

M 105385 x24

1 D3243-1(Ref)

Bracket

B34922

✓ ml 07/12/05

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg d3243

ml 07/12/05 x6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/06 (6)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

ml 07/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Tuesday, 10/2/2007 10:37:00 AM
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Drawing Name: R44 CARGO MIRROR

Job Number: 34922

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-06

X6

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D1048

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1048

Clamp

B30373

AS 07/12/12

X6

17.0

D1049

Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D1049

Saddle

B32797

AS 07/12/18

X6

18.0

D2010104

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2010-104

Arm

B332386 X5

B34672 X6

AS 07/12/12

X6

19.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2011-101

Mirror

B34886 X1

B34922 X5

AS 07/12/12

X6

20.0

ALS41032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 ALS4-1032-130 Insert

M105730

AS 07/12/12

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/21/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:37:00 AM
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Drawing Name: R44 CARGO MIRROR

Job Number: 34922

Part Number: D044715011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A

Bolt

M107641

AS 07/12/12 (X6)

22.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526C1032R10 Screw

M15072

AS 07/12/12 (X6)

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10L Washer

M104374

AS 07/12/12 (X6)

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS.



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 2/12/18 (X6)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-715-011

Location: _____

A

6/2/12/18 (6)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/09/12/15

Job Completion



2007/12/18
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

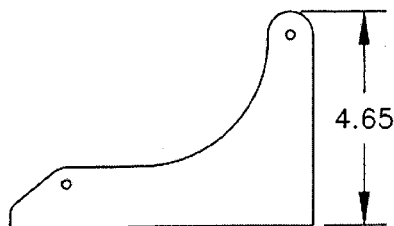
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 ± 0.030
0.000

11.920

11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

8.581

8.206

7.706

1.375

5.273

3.714

4.214

R0.25 (TYP)

3.339

R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

0.500

0.000

0.750

0.500

0.000

GRAIN
DIRECTION

RELEASED
04.02.03

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34822

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